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B22D 11/12(21) Application number: **05202013**(22) Date of filing: **23.07.93**(71) Applicant: **NIPPON STEEL CORP**(72) Inventor: **NAGATA TAKUO**(54) **METHOD FOR TAKING OUT CAST BILLET IN
SMALL LOT CAST SLAB CASTING**

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(57) Abstract:

PURPOSE: To provide a method for taking out a cast billet in a multistrand continuous caster for efficiently executing the casting in small lot of materials.

CONSTITUTION: In the cast billet taking-out method in small lot of cast slab casting, at the time of taking out the small lot of the cast billets 10 obtd. in the vertical type continuous caster for casting the cast billet, the cast fillet is shifted in the right angle direction to the long side or the short side of the cast billet 10 to the drawing direction of a strand in the condition of standing the cast billet 10 and taken out. By this method, as the carry-out treatment of many sizes and small lot of cast billets 10 can efficiently be executed in the limited narrow area and the existing crane and building can plactically be used and the building cost is low, the lowering of the efficiency and the rising of the cost by production in the small lot can be suppressed.

